

Work Order ID 166343***166343***

Page 1

Friday, September 15, 2017 1:20:45 PM

Item ID: D5370-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fitting
Start Date: 9/15/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/22/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: DOB Date: SEP 15 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5370	B								

100

0.00

100

Purchasing

Purchasing

Memo

ISSUE P/O: 37792
VENDOR: MCMASTE CARR
VENDOR PN: 50715K677

0.00

C OF C IS REQUIRED

20DOB
SEP 15 2017

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

20x SEP 17-9-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112 *112* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.40				<u>20</u> Lauter			DAS 16 9-89 17/09/21
120 *120* HAAS 5AXIS HAAS CNC vertical machine #5	Memo DRILL LOCKWIRE HOLES AS PER DWG SECTION A-A	0.00 0.00				<u>20</u>	<u>0</u>		DAS 14 9-89 17/09/22
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>20</u>	<u>0</u>		DAS 14 9-89 17/09/22

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									

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Page 3

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Start Date: 9/15/2017 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 9/22/2017 Req'd Qty: 20.00 *20* Customer:
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 2.00				20	0		DAS 49 9-89 17/09/23
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST/SY</u> Memo	0.00 0.00				20			SEP 25 2017 DAS 6 9-89
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							DAS 21 9-89 SEP 26 2017 68-6DAS 12 21 9-89 SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, September 15, 2017 1:20:43 PM

Page 1

Work Order ID: 166343

166343

Parent Item: D5370-1

D5370-1

Parent Item Name: Fitting

Start Date: 9/15/2017

Required Date: 9/22/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 16-02-01 VERIFIED BY:DD
REV:B 17.09.15 AS PER DWG B DD VERF:DP IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
50715k677		Purchased	No			110	Each	0.0000	1	20			
50715k677									**				
FLARED TUBE FITTING SS													

20x SP 17 9-20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

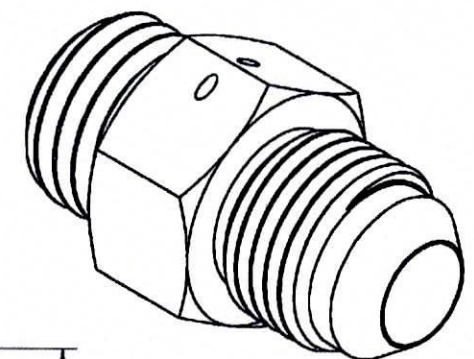
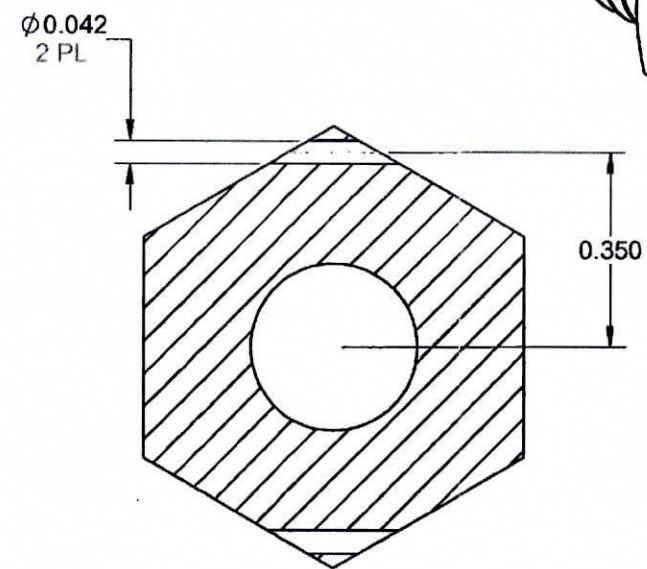
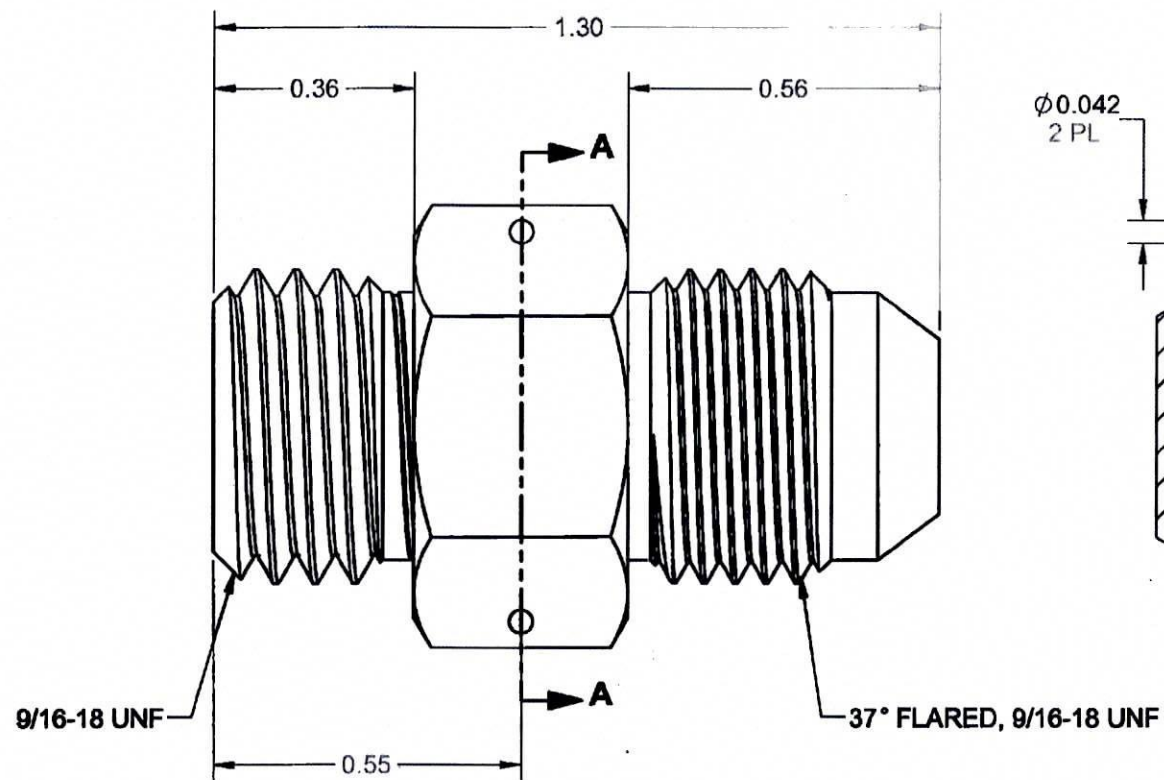
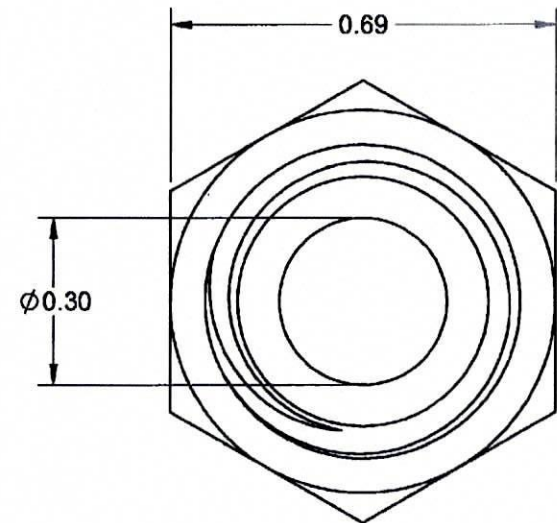


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

SPECIFICATION CONTROL DRAWING



DART PN	DESCRIPTION	TUBE O.D.	VENDOR	VENDOR PN	MATERIAL	WEIGHT	ALTERNATIVE P/N
D5370-1	37 DEGREE FLARED TUBE FITTING	3/8	MCMaster-CARR	50715K677	316 S.S.	0.07 LBS	MS21900K6

12 PL
D5370-1 ADAPTER

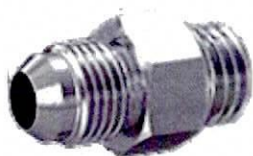
- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.7
 - 7) WEIGHT: SEE TABLE
 - 8) ADD LOCKWIRE HOLES PER SECTION A-A

B	REVISED FITTING SIZE	WK	17.09.07
A	NEW ISSUE	CC	16.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CC	DART AEROSPACE USA INC	
DRAWN	WK	EUGENE, OREGON, USA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5370	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ADAPTER	NTS
DATE	17.09.07	COPYRIGHT © 2016 BY DART AEROSPACE USA INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.			

37 Degree Flared Fitting for Stainless Steel Tubing

Straight Adapter for 3/8" Tube OD, 9/16"-18 UNF Male

In stock
\$10.05 Each
50715K677

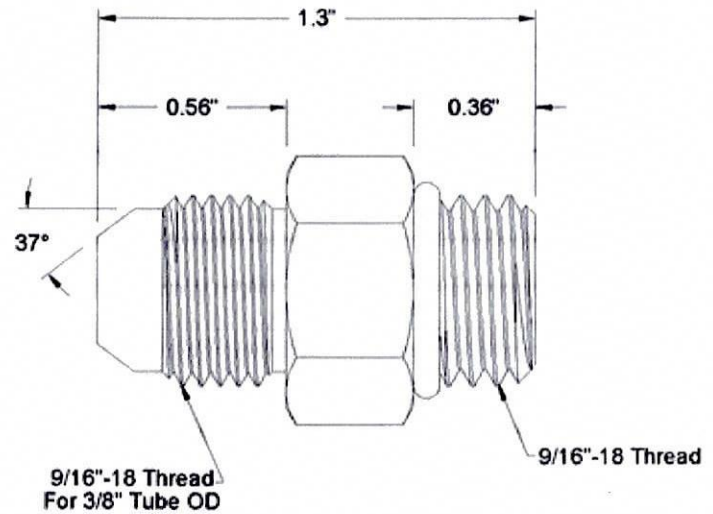
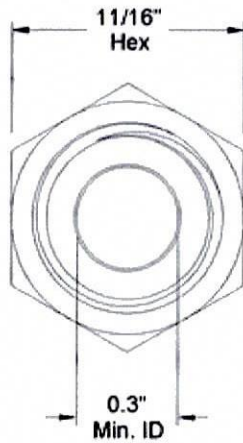


20
X30

For Use With	Air, Isopropyl Alcohol, Natural Gas, Phosphoric Acid, Water
Shape	Straight
Type	Adapter
Tube Connection	
Type	37° Flared
For Tube OD	3/8"
Thread Size	9/16"-18
Thread Type	UNF
Gender	Male
Pipe Connection	
Type	Threaded
Thread Size	9/16"-18
Thread Type	UNF
Gender	Male
Material	316 Stainless Steel
Maximum Pressure	6,000 psi @ 72° F
Maximum Vacuum	Not Rated
Temperature Range	-420° to 1200° F
For Tube	
Material	304 Stainless Steel, 316 Stainless Steel
Fabrication	Welded, Seamless
Specifications Met	ASTM A213, ASTM A249, ASTM A269
Specifications Met	ISO 8434, JIC, SAE J514
RoHS	Compliant

Achieve a tight metal-to-metal seal with these flared fittings. Also known as JIC (Joint Industrial Council) fittings, they connect to tubing that has been flared to 37°. Fittings are 316 stainless steel for excellent corrosion resistance.

Fittings without swivel nut require a nut and a sleeve (ferrule) for each tube end.



McMASTER-CARR CAD
<http://www.mcmaster.com>
 © 2014 McMaster-Carr Supply Company
 Information in this drawing is provided for reference only.

PART NUMBER **50715K677**
 Type 316 Stainless Steel 37° Flared
 Straight Adapter

The information in this 3-D model is provided for reference only.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37792**

Purchase Order Date 9/15/2017

PO Print Date 9/15/2017

Page Number 1 of 2

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
2017/09/15

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	50715k677 As per Dwg D3370 Rev B B166343	FLARED TUBE FITTING SS	9/19/2017 Yes 9/19/2017		20.00 Each	\$10.05	\$201.00
						Line Total:	\$201.00
3	98296A914 1 PACK OF 100	slotted spring pin	9/19/2017 Yes 9/19/2017		100.00 Each	\$0.08	\$7.68
						Line Total:	\$7.68
4	91253A190 1 PACK OF 25	flat head socket cap screw	9/19/2017 Yes 9/19/2017		25.00 Each	\$0.57	\$14.16

Note:

9/15/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Dart Aerospace Ltd

Purchase Order
PO37792
Order Placed By
Diane Baker

McMaster-Carr Number
8668497-01

Page 1 of 1

09/15/2017

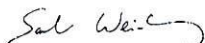
Line	Product	Ordered	Shipped
1	50715K677 37 Degree Flared Fitting for Stainless Steel Tubing, Straight Adapter for 3/8" Tube OD, 9/16"-18 UNF Male <i>517/0121</i>	✓ 20 Each	20
2	98296A914 Steel Slotted Spring Pins, 3/16" Diameter, 1-1/2" Long, Packs of 100	1 Pack	1
3	91253A190 Black-Oxide Alloy Steel Hex Drive Flat Head Screw, 8-32 Thread Size, 5/16" Long, Packs of 25	1 Pack	1

SP 17-9-20

McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 46045779 Purchase Order: PO37792 Release: McMaster-Carr Number: 8668497-01		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 15-Sep-2017 Shipper's Export Declaration (SED): NO EEI 30.36			
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Tax Number:	
Forwarding Agent:		Billing Attention: Shipping: Dart Aerospace Ltd Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	50715K677 37 Degree Flared Fitting for Stainless Steel Tubing, Straight Adapter for 3/8" Tube OD, 9/16"-18 UNF Male Country of Origin: United States Schedule B #: 730729 ECCN #: 2B999 NLR	20 EA	\$10.05	\$201.00
2	98296A914 Steel Slotted Spring Pins, 3/16" Diameter, 1-1/2" Long, Packs of 100 Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	1 PK	\$7.68	\$7.68
3	91253A190 Black-Oxide Alloy Steel Hex Drive Flat Head Screw, 8-32 Thread Size, 5/16" Long, Packs of 25 Country of Origin: United States Schedule B #: 731815 ECCN #: EAR99 NLR	1 PK	\$14.16	\$14.16
	NOTE These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations.			
	NOTE Tracking number(s) for this shipment: CPK005715573			
	Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.			

SP A 9-20

Shipping Weight (in kgs): 2		Number of Packages: 1		Invoice Amounts:		Merchandise Amount: \$222.84 Canadian GST/HST: \$30.65 Shipping Charges: \$12.90 Total (In USD): \$266.39	
Package Dimensions: 25 X 16 X 8 CM = .003 CUBIC M				Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days			
Authorized Signature: 		Date: 15-Sep-2017		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA		(by wire transfer) Bank of America 222 Broadway New York, NY 10038 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg		Title: Operations Mgr.		Page 1 of 1			

